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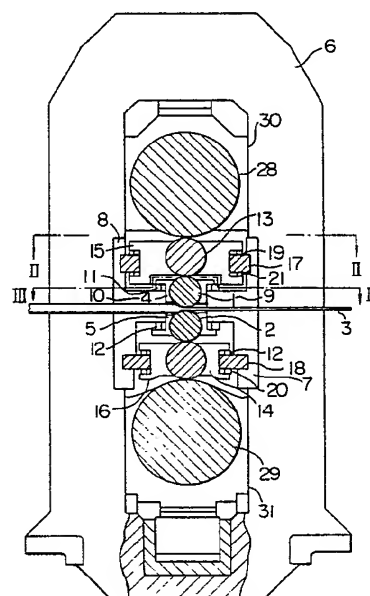
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⑤④ **Rolling mill and method for rolling a sheet material.**

⑤⑦ A rolling mill having a pair of intermediate rolls (13, 14) interposed between a pair of working rolls (1, 2) exerting a working roll bending force and a pair of backing rolls (28, 29) so that the intermediate rolls (13, 14) are axially displaced in conformity with the lateral length or width of a rolled material (3) and the intermediate roll bending force larger than the working roll bending force is exerted thereto, and the shape of the sheet (3) is controlled by adjusting the axial position of the intermediate rolls (13, 14) and by exerting the working and intermediate roll bending forces thereto.



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ROLLING MILL AND METHOD FOR
ROLLING A SHEET MATERIAL

1 BACKGROUND OF THE INVENTION

This invention relates to a rolling mill having a novel roll arrangement and a material shape controlling function and, more particularly, to a
5 rolling mill having working rolls of a small diameter to make an effective rolling operation and effective control of the shape of a rolled material.

Recently, in the field of the rolling production and especially rolling of sheet materials,
10 the improvement in the accuracy of thickness of the rolled sheet material in the longitudinal direction has almost been accomplished and vigorous investigation has further been made to the improvements in the accuracy of thickness of the sheet in the lateral direction and
15 in the shape (flatness) of the sheet and decrease in the rolling power from the requirements for saving of resources and energy. To satisfy such requirements, it is necessary to make a rolling mill having working rolls of a small diameter to provide stable sheet shape
20 and high control performance thereto.

In a quadruple rolling mill which is a typical conventional rolling mill, however, it is difficult to satisfy those requirements in view of its fundamental characteristics. To solve this problem,
25 the inventor found the basic limitations of the

1 quadruple rolling mill (refer to U.S. Patent No. 3,
818, 743) and invented a new type of a rolling mill
based on a new concept. This type of the rolling
mill includes intermediate rolls interposed between
5 backing and working rolls so that the shape control of
the rolled sheet material is made by adjusting the
axial position of the intermediate rolls in conformity
with the lateral length or width of the sheet material
and applying the working roll bending action to provide
10 a good shape stability and shape control function and
edge drop reducing function, thereby permitting the
diameter of the working rolls to be reduced to be equal
to 25% of the maximum width of the rolled sheet,
although in the conventional quadruple rolling mill
15 practically the diameter of the working rolls is equal
to 35-50% of the maximum width of the sheet.

It is further required in the art to realize
rolling a still thinner and still harder material,
much more saving the energy, much more reducing the
20 edge drop and using a low cost roll coolant. To satisfy
these requirements, it must be necessary to decrease
the diameter of the working rolls much more. Decrease
in such diameter may be accomplished by arranging the
rolls in twelve or twenty stages, such as in a known
25 multiple stage rolling mill. As is known in the art,
however, such a multiple stage rolling mill is dis-
advantageous in that a high grade control technique
is required in view of its geometry, and the construction,

1 operation and maintenance are complex and difficult and
the application is only limited to rolling of specific
hard materials, such as stainless steel.

Therefore, such rolling mill is still
5 insufficient to satisfy the above-mentioned require-
ments. In such rolling mill, the bending moment is
produced on the working roll itself by adjusting the
axial position of the intermediate rolls and bending
the working rolls, but when the rigidity of the shafts
10 of the working rolls is lowered the working rolls
interposed between the sheet material and the inter-
mediate rolls are locally deflected to form a composite
crown or quarter buckling between the center portion of
the sheet material and side portions thereof. To prevent
15 the formation of such composite crown, the working
rolls should have a suitable rigidity against the
deflection for the width of the sheet. According to the
investigation made by the inventor, it was proved that
in case of the working rolls being made of steel the
20 roll diameter should be more than 20% of the width of
the sheet when not using the working roll bending,
and it was preferable that the roll diameter should
be about 10-15% larger than it when using the working
roll bending. Namely, the diameter of the working
25 rolls should be 22-23% of the width of the sheet and
has to be more than 25% of the latter in consideration
of the grinding allowance.

To solve such problems, on the other hand,

1 the inventor has already proposed a rolling mill
utilizing a intermediate roll bending system (refer
to Japanese Patent Laid Open To Public No. 66849/1978).
The idea of this rolling mill is based on the considera-
5 tion that when using working rolls of a small diameter
the small rigidity of their shafts increase the tendency
to follow the profile of the rolls to be supported,
thereby bending the intermediate rolls having an
appropriate rigidity to make the shape control. However,
10 such rolling mill has drawbacks the since the working
roll is in contact with the whole length of the inter-
mediate roll, the portion of the intermediate roll
which is in contact with the working roll and larger
than the width of the sheet acts to strongly bend
15 the working roll, thereby causing an extreme reduction
of the sheet thickness at its side edge portion.

SUMMARY OF THE INVENTION

Therefore, it is an object of the present
invention to provide a rolling mill having working
20 rolls of a small diameter and a simple roll construction
to effectively produce rolled products and make a good
shape control.

Another object of the present invention is
to provide a rolling mill capable of attaining the
25 rolling of a thinner and harder material, increased
energy saving and large decrease in the edge drop.

A further object of the present invention is

1 to provide a rolling mill in which the rolling load is
extremely reduced and a small diameter of backing rolls
can be provided to extremely reduce the manufacturing
cost of the mill itself.

5 A still further object of the present invention
is to provide a rolling mill having working rolls of a
small diameter to minimize the composite crown and
control the sheet crown of the rolled material.

Another object of the present invention is
10 to provide a rolling mill having a mechanism for
always applying a stable and positive roll bending
force to the axially movable intermediate rolls.

A further object of the present invention is
to provide a rolling mill in which thrust loads acting
15 on small diameter working rolls are effectively supported
to solve the problems of the strength and life of such
working rolls.

A still further object of the present invention
is to provide a method for rolling a material in which
20 the intermediate roll bending function and the working
roll bending function are utilized to provide a very
good shape throughout the width of the rolled material
and control the sheet crown.

According to the present invention, there is
25 provided a rolling mill comprising a pair of working
rolls brought into contact with a material to be
rolled, a pair of intermediate rolls positioned
vertically outwardly of the respective working rolls

1 to contact therewith, a pair of backing rolls for
supporting the respective intermediate rolls, means
for displacing the intermediate rolls to position
the end portions of the roll barrel thereof adjacent
5 to lateral ends of the rolled material and means for
applying a roll bending to the working rolls to control
the shape of the rolled material, wherein there is
further provided means for applying to the inter-
mediate rolls a bending force larger than the bending
10 force acting to the working rolls so that the shape of
the rolled material is controlled by adjusting the
axial position of the intermediate rolls and applying
the working roll bending action and the intermediate
roll bending action.

15 BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a front view of an embodiment of
a rolling mill of the present invention;

Fig. 2 is a view taken along a line II-II of
Fig. 1;

20 Figs. 3 - 6 show an arrangement for supporting
working rolls of the rolling mill and Fig. 3 is a view
taken along a line III-III of Fig. 1, Fig. 4 being a
partly fragmentary view of a metal chock portion,
Fig. 5 being a front view thereof and Fig. 6 being a
25 schematic side view of a roll end portion;

Fig. 7 is a schematic side view of the rolling
mill of the present invention for explaining the

1 meanings of the various reference characters; and

Figs. 8 - 10 are graphs showing various shape control characteristics.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

5 An embodiment of the present invention will be described with reference to the accompanying drawings.

Fig. 1 shows an embodiment of the present invention and Fig. 2 is a view taken along an arrow II-II of Fig. 1 showing a mechanism for displacing an
10 intermediate roll. There is provided a pair of working rolls 1 and 2 having a small diameter for rolling a material to be rolled, the working rolls being supported at thier ends by metal chocks 4, 5. Each of the metal chocks 4, 5 is disposed for upward and downward move-
15 ments inside of projections 9, 10 of projecting blocks 7, 8 provided in a window of a roll housing 6 and these projections are provided therein with hydraulic rams 11, 12 for bending the working rolls.

There is also provided a pair of intermediate
20 rolls 13 and 14 which are disposed on the upper and lower sides of the working rolls 1 and 2, respectively, and ends of the intermediate rolls are supported by metal chocks 15, 16. Each of the metal chocks 15, 16 is disposed for upward and downward movements inside
25 of movable blocks 17, 18 which are axially movably mounted on the projecting blocks 7, 8, and the movable blocks 17, 18 are respectively provided therein with

1 hydraulic rams 19, 20 for applying an increased bending
to the intermediate rolls and with hydraulic rams 21,
22 for applying a decreased bending thereto. The
movable block 17 has attached thereto a cylinder 24
5 for pivotally moving a keeper plate 23 having a convex
portion, while a driving metal chock 15' for the
intermediate roll is provided with a concave portion
engaging the convex portion. With such arrangement,
if the movable block 17 and the driving metal chock
10 15' are connected to each other through the keeper
plate 23, the intermediate roll together with the
movable block will be able to be axially moved under
the action of the cylinder 26. In this case, the
intermediate roll chocks and the hydraulic rams 19,
15 20, 21, 22 are moved together and thus the bending
forces can always be applied to the center of inter-
mediate roll bearings 27 by locating the rams in
position. Moreover, the intermediate rolls are larger
in diameter than the working rolls and the bending
20 forces on the intermediate rolls are larger than those
on the working rolls.

There are further provided backing rolls 28
and 29 for supporting the intermediate rolls 13, 14,
respectively, the backing rolls being larger in diameter
25 and higher in rigidity than those of the inter-
mediate rolls. Metal chocks 30, 31 for the backing
rolls are vertically movable provided in the roll
housing.

1 With the arrangement described above, when
replacing the intermediate rolls, the keeper plate 23
is released by the hydraulic cylinder 24 to permit the
removal of only the roll assembly, while the movable
5 block 17 remains in the roll housing 6. In this embodi-
ment, the hydraulic rams 11, 12 for bending the working
rolls are shown for increasing the bending force, but
rams for decreasing the bending force may be also
provided. However, the latter will practically be not
10 necessary and not be shown, because such function can
be accomplished by operating the rams for decreasing
the bending force to the intermediate rolls and outwardly
shifting the ends of the intermediate rolls. Further-
more, the decreased bending of the intermediate rolls
15 is effective to control the compensation for the thermal
crown of the rolls. The main effects of the increased
bendings of the working and intermediate rolls will be
described in detail hereinbelow.

 When it is intended to practically use the
20 rolling mill of the present invention, the problems
of the structural strength should be considered in
order to adopt a sufficiently small diameter of
working rolls. In the rolling mill of the invention,
driving of the working rolls is not permitted in view
25 of the structural strength, and it is, therefore,
desirable to adopt an intermediate or backing roll
driving system. In such case, it is necessary to
consider the effects resulting from the tangential

1 forces acting on the working rolls, such as the
effects of the bending strength and horizontal deflec-
tion of the barrels and necks of the working rolls on
the shape of the rolled sheet and the life against the
5 horizontal forces on the roll neck bearings, the bending
and thrust forces. Figs. 3 - 6 show an example of
the working roll supporting construction in which such
problems are considered. In this example, moreover,
the metal chocks of the working rolls are directly
10 supported by the roll housing 6.

The working roll 1 is supported at its
opposite ends by metal chocks 4, 4' which are, in
turn, supported by needle bearings 50 and maintained
by thrust bearings 51 against axial movement. The
15 thrust force acting on the working roll 1 is not trans-
mitted to the metal chocks, and end portions 52, 53
thereof are directly supported by thrust rollers 54, 55,
56, so that the thrust bearings 51 are only loaded by
a small force. The thrust roller 54 is provided on the
20 roll housing 6 by way of a lever 57. The thrust rollers
55, 56 are pivotally mounted on pins 58 which are, in
turn, supported by a lever 59 to follow upward and
downward movements of the working roll 1. Each of the
thrust rollers contains an anti-friction bearing for
25 rotation about an axis deviated at 90° by the rotation
of the working roll 1. When replacing the rolls,
a keeper plate 60 attached to the roll housing 6 is
released to allow the lever 61 supporting the thrust

1 roller to rotate about a pin 63 provided on a supporting
table 62 to open the passage for the working rolls.
There is further shown a stop nut 64 in the drawing.
With the arrangement, the radial load caused by the
5 horizontal force and the bending force is supported by
the needle bearing 50 and the thrust force is directly
supported by the thrust rollers 54, 55, 56 on the
working rolls so that even when the diameter of the
working rolls is fairly small the problems mentioned
10 above will not be raised.

Fig. 7 is a schematic side elevation of the
rolling mill to show some relation of the components
by various reference characters. In the drawing, F_i is
an intermediate roll bending force and F_w is a working
15 roll bending force. The end portions of the roll
barrel of the intermediate roll is positioned on or
near the vertical end surface of the sheet to be
rolled, and this condition is shown by a character δ .
Practically, this character shows an axial distance
20 between the end portion of the intermediate roll and
the end of the rolled material. In case of an inter-
mediate roll having a stepped end portion, the stepped
portion of the roll end is registered with the end
portion of the intermediate roll. In general, the
25 end portions of the intermediate rolls are formed in
a converging configuration to reduce the stress
concentration in their stepped end portions and prevent
the rolls from being damaged, but the converging ends

1 are out of contact with adjacent working and backing
rolls so that the converging outermost ends do not
substantially contribute the rolling operation. It
will, therefore, be understood that the position of the
5 end portions of the roll barrel of the intermediate
roll for determining the value δ in case of the roll
having converging ends should be on or near the boundary
between the contact end non-contact areas thereof with
the adjacent rolls and practically on or near the base
10 portions of the converging ends. In other words, the
converging outermost end portions should be excluded
from the position for determining the value δ .

The shape control characteristics of the
rolling mill according to the present invention will
15 be described with reference to Fig. 8 in comparison
with known rolling mills.

In the drawing, the shape control character-
istics referred to as type A are of a known rolling
mill in which the axial movement of the intermediate
20 rolls and the bending of the working rolls are
provided, the characteristics referred to as type B
being of a known rolling mill of the above-described
intermediate roll bending system and the characteristics
referred to as type C being of the rolling mill of the
25 present invention in which the axial movement of the
intermediate rolls and the bending of the intermediate
and working rolls are provided (provided that the bending
force of the intermediate rolls is larger than that of

1 the working rolls.) If the diameter of the working
roll is theoretically more than 20% larger than the
width of the sheet and practically more than 25%
larger than it, the drawbacks of the type A will not
5 take place, and thus there will be described the result
theoretically calculated in respect of a rolling mill
including working rolls having a diameter of 210 mm
equal to 17.5% of 1200 mm of the maximum sheet width.
The diameter of the intermediate rolls is 420 mm, the
10 diameter of the backing rolls being 1350 mm and the
length of the roll barrel being 1420 mm, but in the
type B the effective barrel length l of the backing
rolls being 900 mm and thus resulting from the fact
that in case of the maximum width of the sheet being
15 1200 mm the minimum width is within the range of 600 -
750 mm and the shape control becomes difficult as the
width becomes small. The result of the calculation
shows the fact that in case of the effective barrel
length being 900 mm the shape control is insufficient
20 when the width is less than 750 mm, but the shape
control is possible when the width is within the range
of 750 - 1200 mm. Fig. 8 shows a distribution of the
sheet thickness in the lateral direction when cold
rolling was made to a width of 1200 mm under the above-
25 described conditions.

In type A, it is necessary to locate the
end portions of the intermediate rolls inside of the
adjacent ends of the sheet material and in this case

1 the value δ is 35 mm. In this event, a slightly convex
crown is caused on the center portion of the width of
the sheet material and concave crowns are caused at one
quarter and three quarters of the sheet width and thus
5 a composite crown is caused as a whole. This is called
as a secondary elongation or pocket in the sheet shape
which is difficult to treat with practically. The
cause of it is that the positioning of the end portions
of the intermediate rolls inside of the sheet ends
10 provides no support against the counter forces derived
from the rolled material and thus a large bending
moment acts on the working rolls not to provide a
bending rigidity necessary to continuously transmit
the axial deflection of the working rolls throughout
15 their length. If the amount of the inward shift is
decreased and the compensation therefor is made by the
working roll bending, a fairly large composite crown
will be caused.

In the type B, it will be found that the
20 effect of the intermediate roll bending is sufficiently
brought forth to allow the control of the crown in a
wide range from the concave crown to the convex
crown. Such a composite crown as caused in the type
A using the small diameter of the rolls is not formed,
25 but a large reduction in the thickness at the ends
of the sheet is caused not to satisfy the requirements
to control the shape of the sheet well and to obtain
a uniform rectangular form in section.

1 In the type C, there is shown the fact that the
rate of the displacement of the intermediate roll is
smaller than that in the type A and by calculation the
end portion of the intermediate roll is registered with
5 the end of the sheet and the deflection of the working
roll is altered by the intermediate roll bender to
prevent the reduction in the thickness at the ends of
the sheet as caused in the type B. This difference
results from the fact that although it has been already
10 described in the type B the working roll is bent by the
spring action caused by the roll-flattening due to
contact of it with the roll barrel outside of the width
of the sheet, whereas in the type C such action is
minimized by the effect of the displacement of the
15 intermediate roll.

Fig. 9 shows a comparison of the conditions in
which the sheet crown is minimized within the range of
no occurrence of the composite crown in the types B and
C. The type C has a smaller crown than that of the
20 type B. Furthermore, when the working roll bender is
applied in the type C, the crown is further improved,
but when the working roll bending force increases over
a certain extent, the shape control should not be made
throughout the width of the sheet, but should be made
25 locally and overall control should be made by the inter-
mediate roll bending. Thus, even if the installation
capacity of the work roll bender were increased over the
installation capacity of the intermediate roll bender,

1 it would be necessary to reduce the output of the work
roll bender below the output of the intermediate roll
bender. In this case, the working roll bending extremely
acutely affects to vary the shape of the sheet ends
5 and thus it is necessary to make a fine control and
increase the capacity largely. In contrast, the inter-
mediate roll bending requires a overall control and a
large capacity of bending device because of the high
bending rigidity of the rolls in general. If the working
10 roll bender is similarly applied in the type B, an excess
contact with the intermediate rolls causes a composite
crown as shown in Fig. 10 not to be brought into practice.

In this manner, the type C rolling mill
according to the present invention brings forth the
15 effects that a small diameter of the working rolls can
be used to provide a good shape of the rolled sheet
material throughout its width and good crown control
thereby accomplishing an efficient rolling operation and
largely reducing the rolling load to reduce the diameter
20 of the backing rolls and thus the manufacturing cost
of the rolling mill. Such effects may also be brought
forth by the type B rolling mill, if the intermediate
rolls are changed by different ones having a suitable
effective barrel length as the width of the sheet
25 varies, but there are drawbacks of difficulty in choice
of the suitable effective barrel length, low productivity
due to increase in the time of roll change and lack
of control function by changing the effective length in

1 respect of the same width of the sheet, and it is
apparent that the type C is superior to the type B.

Furthermore, the type A requires to position
the end portion of the intermediate roll inside of the
5 sheet end in order to utilize the merit that no crown
is provided on the rolls. This is disadvantageous in
case that it is not desirable to form an uneven brilliance
on the surface of a rolled material, such as a rolled
aluminum sheet. On the contrary, the method of the
10 present invention can ordinarily position the end
portion of the intermediate roll outside of the sheet
end by the action of the intermediate roll bending.
Moreover, in the type A, if the end portion of the
intermediate roll is positioned inside of the sheet
15 end, there is a point of infinite width rigidity at
which no deflection is equivalently caused on the
working roll by the rolling load, but the small
diameter of the working roll subject to the present
invention has no such function, because the end of
20 the intermediate roll is generally positioned adjacent
to the end of the sheet. It is, therefore, necessary
to control the intermediate roll bending force in
conformity with the rolling load. Since this necessary
bending force has a different proportional constant to
25 the rolling load depending upon the sheet width, as the
sheet width is a known factor, the intermediate roll
bending force can be controlled in proportion to the
rolling load.

1 It will further be understood from Fig. 9 that
the working roll bending force mainly affects the end
portion of the sheet and it can not be said that the
working roll bending force does not affect the center
5 portion of the sheet. In order to prevent the center
portion from being affected by the working roll bending
force, it is preferable to control the intermediate roll
bending in interlocking relation to the control of the
working roll bending.

CLAIMS:

1. A rolling mill comprising a pair of working rolls (1, 2) brought into contact with a material (3) to be rolled, a pair of intermediate rolls (13, 14) positioned vertically outwardly of the respective working rolls to contact therewith, a pair of backing rolls (28, 29) for supporting the respective intermediate rolls, means (17, 26) for axially displacing the intermediate rolls to position the end portions of the roll barrel thereof on or near vertical lateral end surfaces of the rolled material and means (11, 12) for applying a roll bending to said working rolls to control the shape of the rolled material, wherein there is further provided means (19, 20, 21, 22) for applying to the intermediate rolls a bending force larger than the bending force acting on said working rolls so that the shape of the rolled material is controlled by adjusting the axial position of the intermediate rolls and by applying the working roll bending action and the intermediate roll bending action.

2. The rolling mill of Claim 1, wherein said intermediate rolls (13, 14) are supported by metal chocks (15, 16) with which members (17, 18) are axially movable, and said members are provided with hydraulic rams (19, 20, 21, 22) for applying the roll bending force through said metal chocks to said intermediate rolls.

3. The rolling mill of Claim 2, wherein said

- members comprise movable blocks (17) extending between roll housings (6) on driving and operating sides or between projecting blocks (7, 8) located in windows of said housings, respectively, said metal chocks (15, 16) of the intermediate rolls being vertically movably disposed within said movable blocks and mechanisms (23, 24) for connecting and disconnecting the axial movements of the metal chocks of the intermediate rolls and the movable blocks.
- 10 4. The rolling mill of Claim 2 or 3, wherein said hydraulic rams (19, 20, 21, 22) are constituted by hydraulic rams for increasing the bending and hydraulic rams for decreasing the bending.
5. The rolling mill of Claim 2, wherein said
- 15 working rolls (1, 2) are supported by metal chocks (4, 5) including bearings (50) for mainly supporting radial loads and mechanisms (54, 55, 56, 57, 58, 59, 60) for directly supporting the working rolls to support thrust loads acting on the working rolls.
- 20 6. The rolling mill of Claim 2, wherein said pair of working rolls (1, 2) is supported by metal chocks (4, 5) which are vertically movably located within projections (9, 10) provided on said housings (6) or projecting blocks (7), and said projections are provided
- 25 with at least hydraulic rams (11, 12) for increasing the bending.
7. A rolling mill comprising a pair of working rolls (1, 2) brought into contact with a material (3)

to be rolled, a pair of intermediate rolls (13, 14) positioned vertically outwardly of the respective working rolls to contact therewith, a pair of backing rolls (28, 29) for supporting the respective intermediate rolls, 5 means (17, 26) for axially displacing the intermediate rolls to position the end portions of the roll barrel thereof on or near vertical lateral end surfaces of the rolled material and means (11, 12) for applying a roll bending to said working rolls to control the shape of 10 the rolled material, wherein there is further provided means (19, 20, 21, 22) for applying to the intermediate rolls a bending force larger than the bending force acting on said working rolls so that the shape of the rolled material is controlled by adjusting the axial 15 position of the intermediate rolls and by applying the working roll bending action and the intermediate roll bending action, and the diameter of said working rolls is smaller than 25% of the maximum sheet width of the rolled material.

20 8. A method of rolling a sheet material (3) to be rolled by a rolling mill comprising a pair of working rolls (1, 2) brought into contact with the material, a pair of intermediate rolls (13, 14) positioned vertically outwardly of the respective working rolls to contact 25 therewith, a pair of backing rolls (28, 29) for supporting the respective intermediate rolls, means (17, 26) for axially displacing the intermediate rolls to position the end portions of the roll barrel thereof

on or near vertical lateral end surfaces of the rolled material and means (11, 12) for applying a roll bending to said working rolls to control the shape of the rolled material, wherein there is provided means (19, 20, 21, 5 22) for applying to the intermediate rolls a bending force larger than the bending force to said working rolls whereby the shape or crown of the rolled material can be controlled by controlling the axial movement of the intermediate rolls, work roll bending action and 10 intermediate roll bending action in combination in such a manner that control of the shape or crown of the rolled material across the width thereof is mainly effected by the intermediate roll bending and controll of the edge portions of the rolled material is mainly effected by 15 work roll bending.

FIG. 1

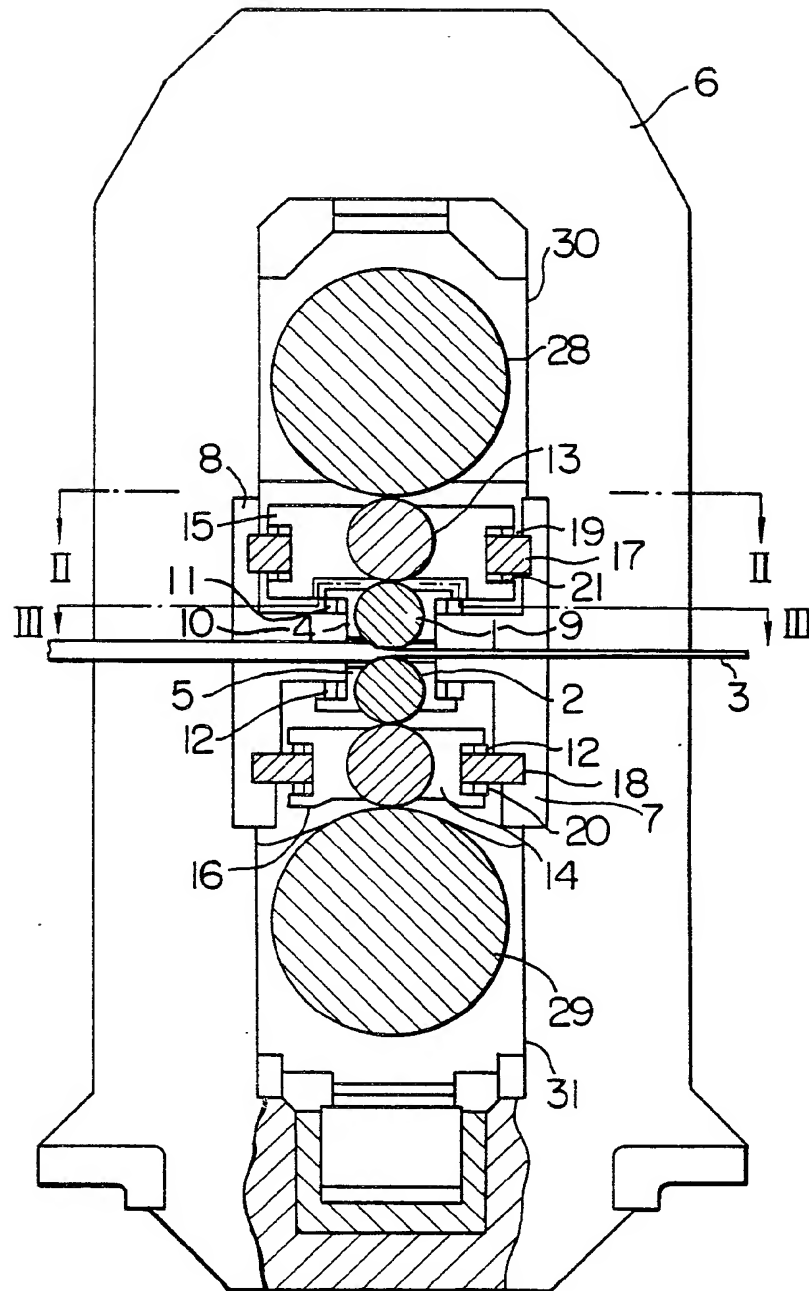


FIG. 2

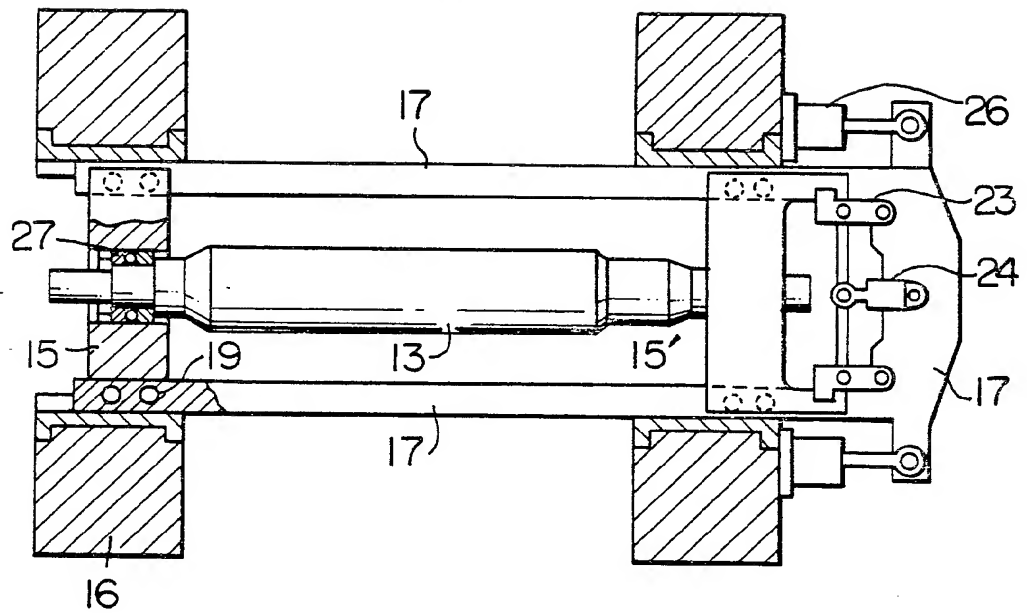


FIG. 3

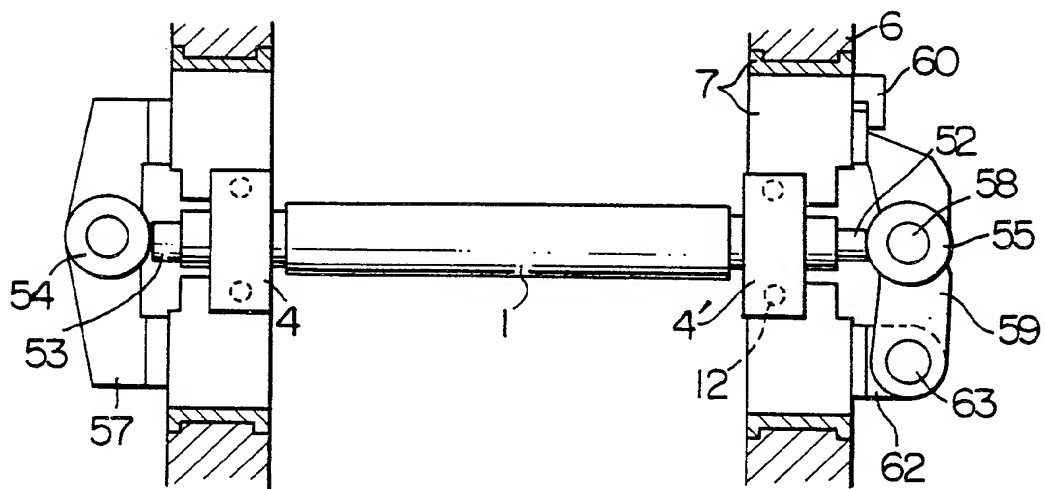


FIG. 4

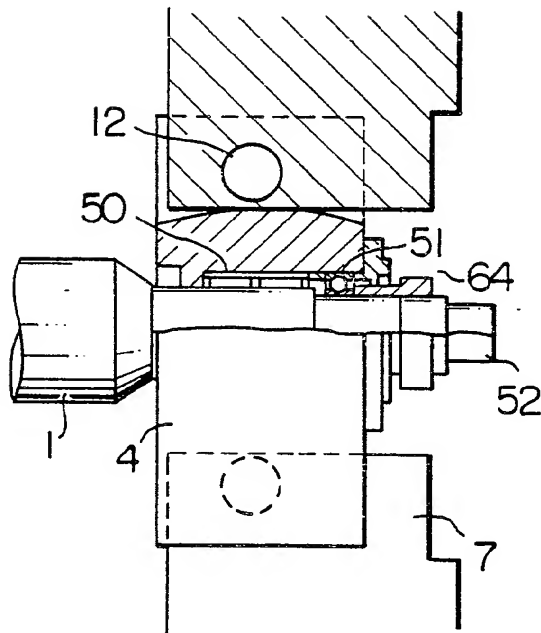


FIG. 7

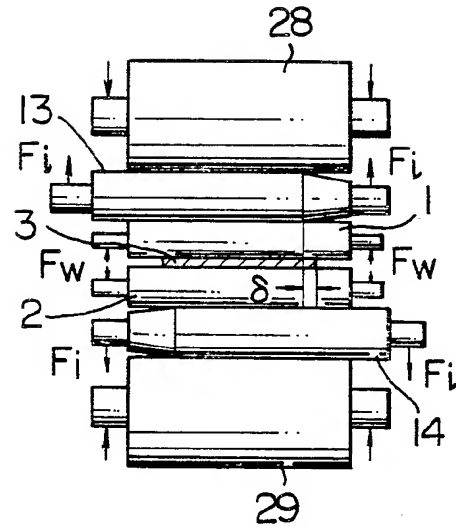


FIG. 5

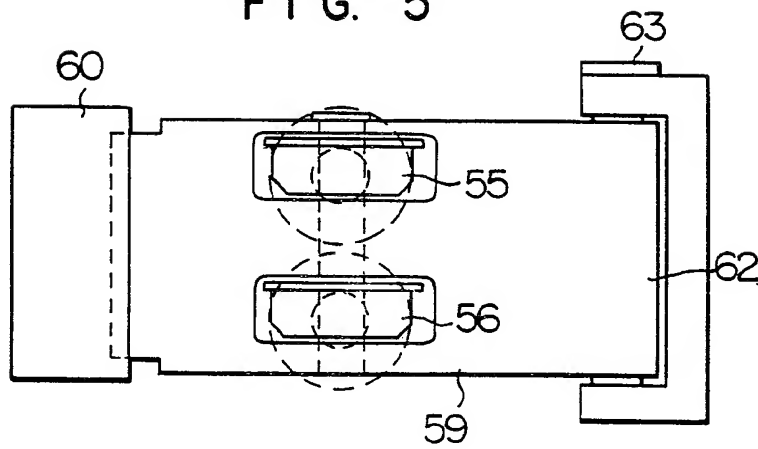


FIG. 6

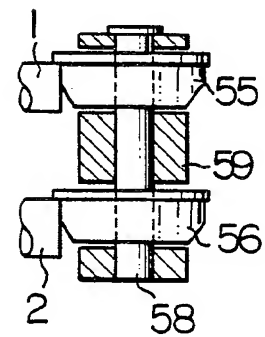


FIG. 8

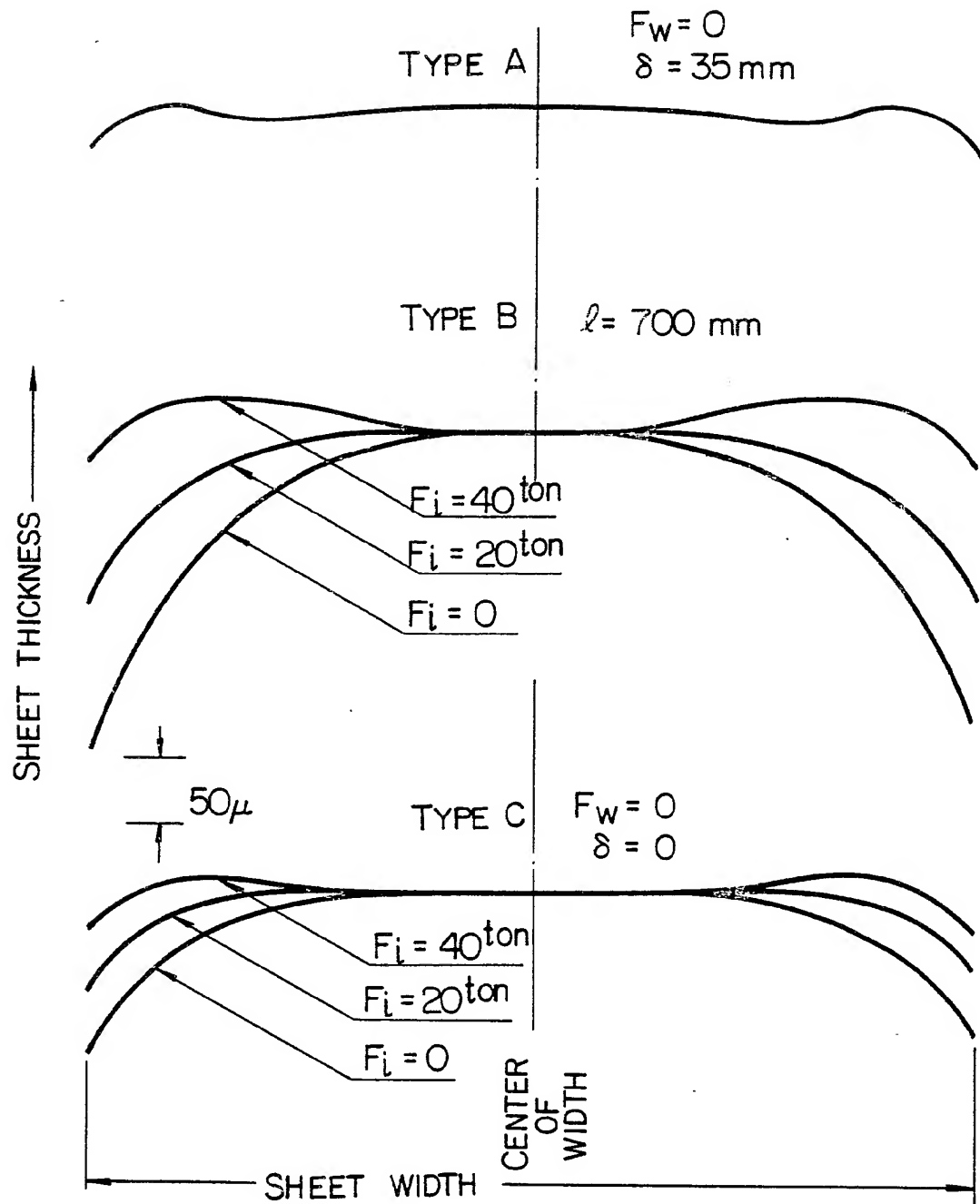


FIG. 9

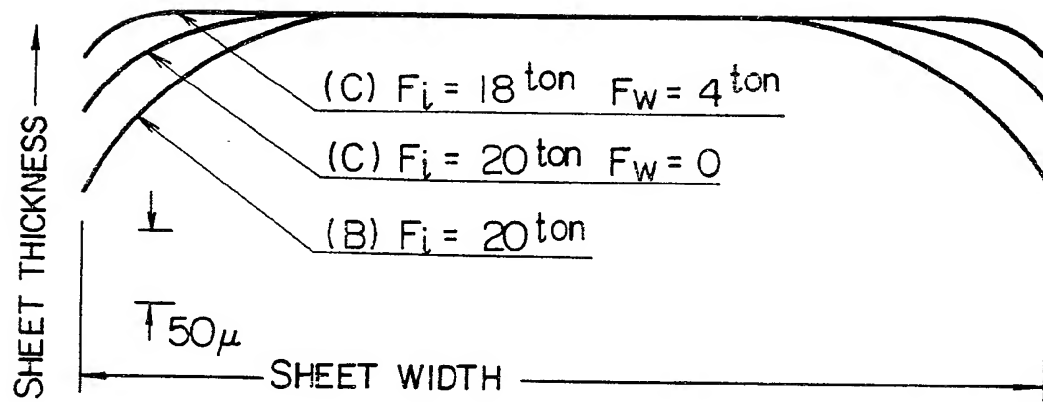
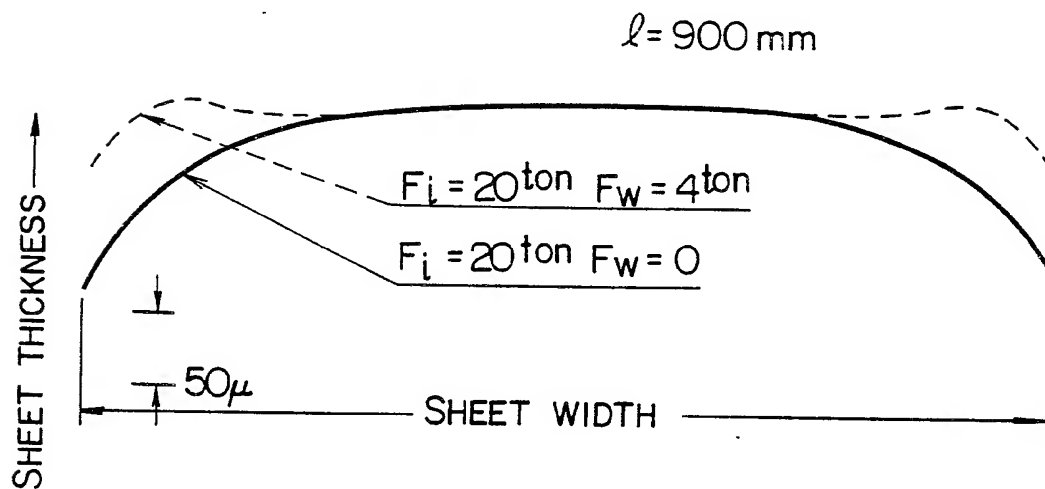


FIG. 10






European Patent
Office

EUROPEAN SEARCH REPORT

0026903

Application number

EP 80 10 5897

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int. Cl. ³)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
D	<u>US - A - 3 902 345</u> (SHIDA) * Claims 1,2; figure 1 * ---	1-8	B 21 B 31/18 37/08 // 29/00
	<u>DE - A - 2 752 750</u> (HITACHI) * Page 20, paragraph 2; figure 5 * & US - A - 4 194 382 & JP - A - 53 - 66849 ---	1-4, 7 8	
	<u>US - A - 3 334 506</u> (HICKS) * Claim 1; figure 4 * ---	1	TECHNICAL FIELDS SEARCHED (Int. Cl. ³)
	<u>DE - A - 2 335 809</u> (HITACHI) * Claims 1,2; figure 1 * & US - A - 4 162 627 ---	1-8	B 21 B
A	IRON AND STEEL ENGINEER, vol. 56, no. 8, August 1979 PITTSBURGH (US) T. FURUYA e.a.: "New design 6-h cold mill (HC mill) solves shape problems" pages 40-45 ---	1	CATEGORY OF CITED DOCUMENTS
A, P	<u>DE - A - 2 950 473</u> (NIPPON STEEL) ---	1	X: particularly relevant A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention E: conflicting application D: document cited in the application L: citation for other reasons
D	<u>US - A - 3 818 743</u> (KAJIWARA) * Abstract * -----		
 The present search report has been drawn up for all claims			&: member of the same patent family, corresponding document
Place of search		Date of completion of the search	Examiner
The Hague		09-01-1981	VERMEESCH